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Internal debeader 90 – 450 mm.
User guide 2012

1. **Study the overview picture, showing the order of assembly the various items involved.**
2. **Select the correct cutter head and legs sizes for the pipe involved.**
3. **Position the assembly into the end of the pipe with the cutter head in its cutting position, adjust and tighten the legs so that the rollers are just in contact. Ensure the head are free to rotate and readjust if to tight.**
4. **Reset the head to collapsed position, and ensure that the screws are fully tightened.**
5. **Fasten the plastic bead catcher.**
6. **Secure the one meter torque rod to the cutter head with the snap lock.**
7. **Select the correct support disc and adjust their legs for centralized fit into the pipe. Small pipe diameter have round disc only.**
8. **Fasten the flexible joint (the short rod) to the support disc as amply on the one meter torque rod.**
9. **Slide the cutter head into the pipe in its retracted position.**
10. **Push the cutter until it engages over the bead, the engagement of the bead can normally be felt and heard.**
11. **Turn the handle clock vice to apply a cutting action. This movement will approach the cutter head towards the pipe bore, enabling the cutter blade to cut into the bead. Continue winding in clock vice direction until the bead is removed.**
12. **Turn the handle antic clock vice to retract the cutter head and control that the bead have been retained.**